

Work Order ID 85256

June-05-12 9:12:37 AM

85256

Page 1

Item ID: D3535-23

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearshoe

Stop ***NS2***

Start Date: 05/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/05 Tooling:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3535	Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

304 .040"

20 0 Jm
12-6-11

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

20 0 Jm
12-6-11

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Salva/21

cauto
+70

Work Order ID 85256

June-05-12 9:12:38 AM

85256

Page 2

Item ID: D3535-23 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearshoe
 Start Date: 05/06/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 19/06/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130									
Brake NC	Memo	0.00							
Brake NC	1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT83262-Form joggle as per Dwg D3535 using Jig DT81583-Identify as D3535-23								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 10:50 OVEN TEMPERATURE: 300 FINISH TIME: 1:00								

Work Order ID 85256

June-05-12 9:12:38 AM

85256

Page 3

Item ID: D3535-23

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearshoe

Stop ***NS2***

Start Date: 05/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

20 x ϕ Unload

170

Identify as per dwg & Stock Location: FP-1

0.00

170

Packaging

Memo

0.00

Packaging

20 ϕ BL 12-6-26

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/6/27

12-06-27

Picklist Print

June-05-12 9:12:42 AM

Page 1

Work Order ID: 85256

85256

Parent Item: D3535-23

D3535-23

Parent Item Name: Wearshoe

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	453.1329	1.3615	28.66316			

M304S20GA

**

304/316 .040 Sheet

Location	Loc Qty	Loc Code
001	52.6444105	
121192	52.6444105	
MAT020	400.4885	
117933	27.3442	
118400	5.3723	
118964	23.2	
119346	29.8	
121380	58.772	
121901	256	121901

Jm
12-6-10

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Other <input type="checkbox"/> </div> <div> Engineering Quality <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Offset/Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unauthorized <input type="checkbox"/>											

FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			Hardware <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong Drill Holes <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many			General <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing			<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material		<input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____	

DART AEROSPACE LTD		Work Order:	#5256
Description: Wearshoe		Part Number:	D3535-23
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.888"	✓		V	mm01
2.000	+/-0.010	2.005"	✓		✓	mm01
4.750	+/-0.010	4.753"	✓		✓	mm01
9.500	+/-0.010	9.503"	✓		V	ProdW302
14.250	+/-0.010	14.250"	✓		MT	HB-01
17.750	+/-0.010	17.750"	✓		MT	
23.140	+/-0.010	23.140"	✓		MT	
28.530	+/-0.010	28.530"	✓		MT	
33.920	+/-0.010	33.920"	✓		MT	
39.310	+/-0.010	39.310"	✓		MT	
44.700	+/-0.010	44.700"	✓		MT	
48.200	+/-0.010	48.200"	✓		MT	
52.850	+/-0.010	52.850"	✓		MT	
Ø0.188	+0.005/-0.001	0.188"	✓		V	mm01
48.00	+/-0.030	48.00"	✓		MT	
39.00	+/-0.030	39.00"	✓		MT	
32.00	+/-0.030	32.00"	✓		MT	
24.00	+/-0.030	24.00"	✓		MT	
16.00	+/-0.030	16.00"	✓		MT	
8.00	+/-0.030	8.006"	✓		V	mm01
6.00	+/-0.030	6.004"	✓		V	mm01
0.300	+/-0.010	0.298"	✓		V	mm01
0.300	+/-0.010	0.297"	✓		V	mm01
0.038	+/-0.010	0.037"	✓		V	mm01

Measured by:	JM	Audited by:	S	Prototype Approval:	N/A
Date:	12-6-10	Date:	12/6/11	Date:	N/A

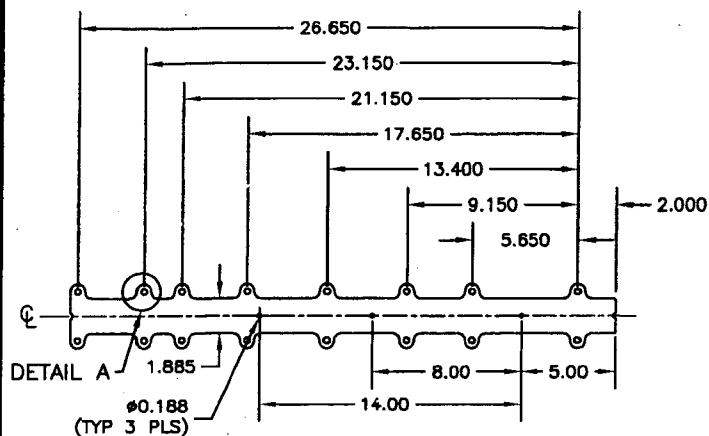
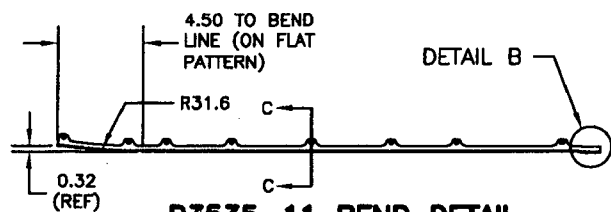
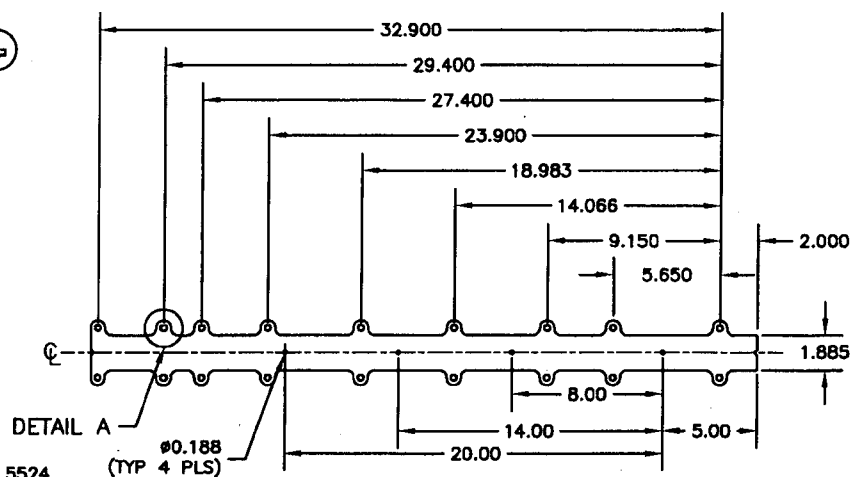
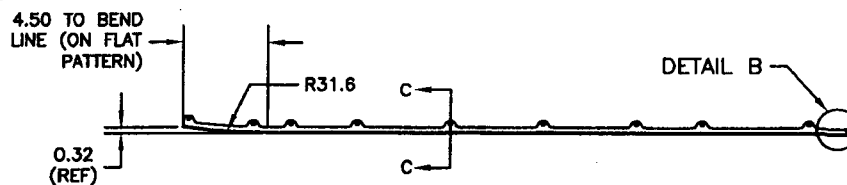
Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	DD

DART

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07.04.17

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85256 MJS
12/06/05

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3535
DATE	TITLE	SHEET 1 OF 7
07.04.17	WEARSHOE	SCALE
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

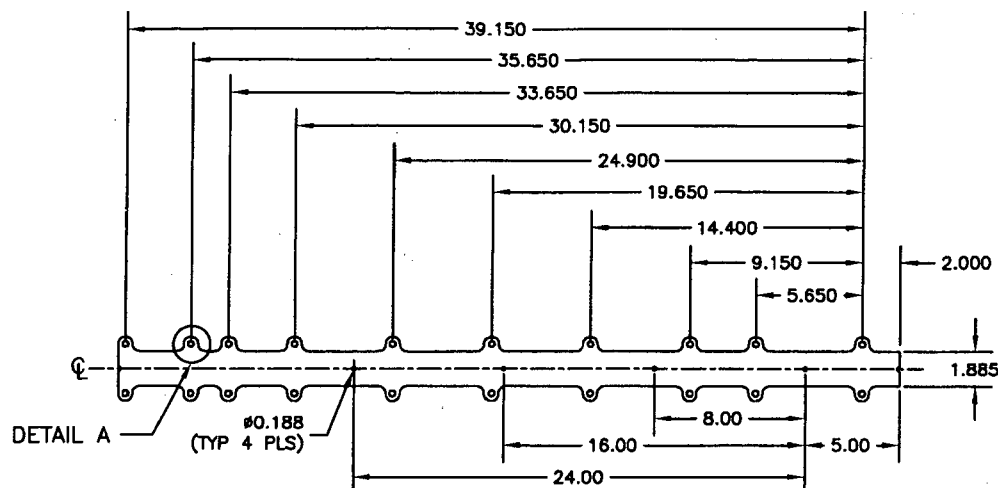
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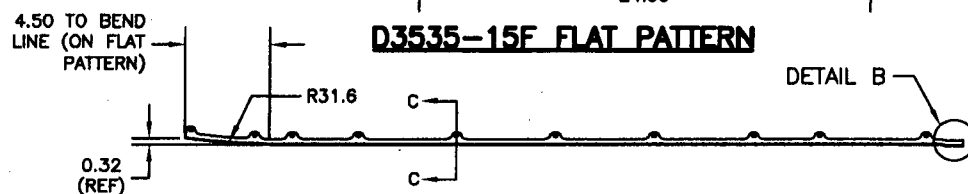
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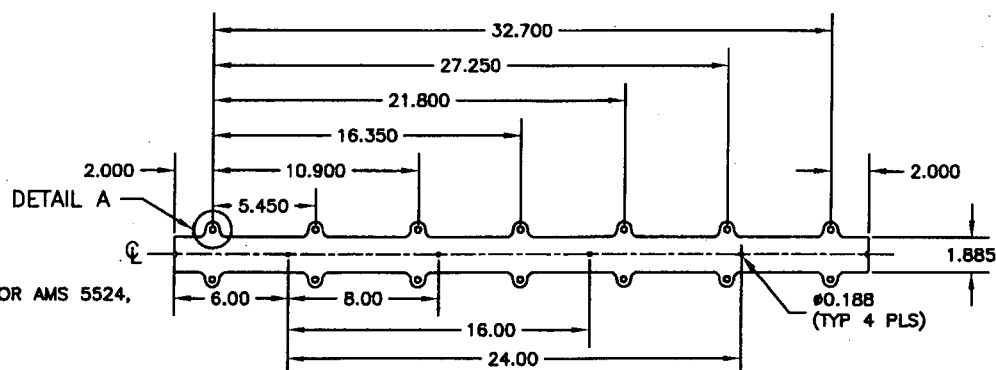
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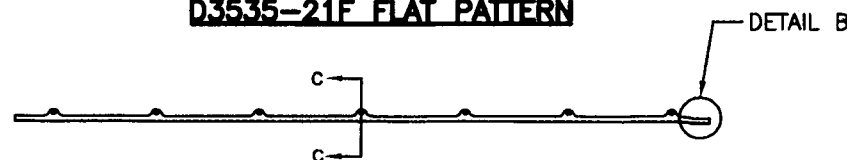
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT ϕ

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL SHARP EDGES TO 0.010 MAX

7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION

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DART AEROSPACE USA, INC.
PORT HADLOCK, WA

PORT HADLOCK, WA

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CKED

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21

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DATE _____

07.04.17

WEARSHOE

REV. B
SHEET 2 OF 7

SCALE

1:10

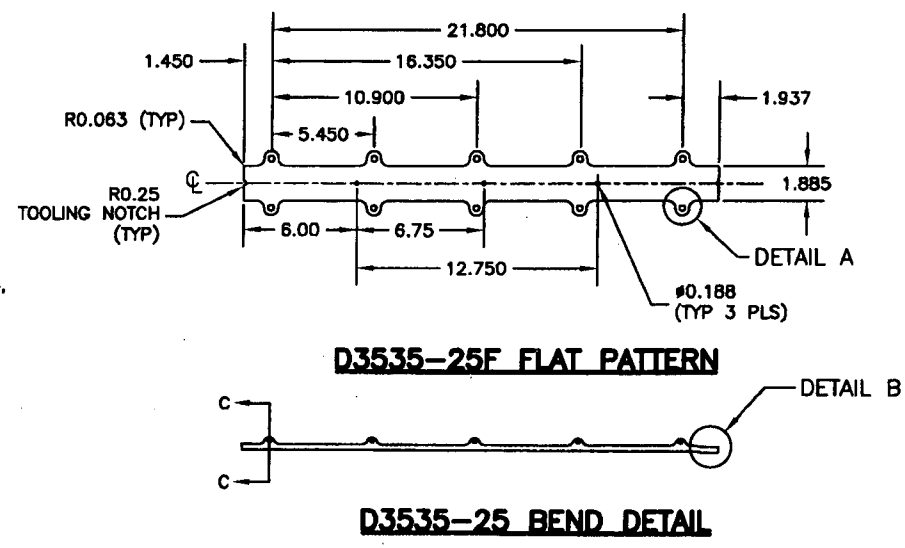
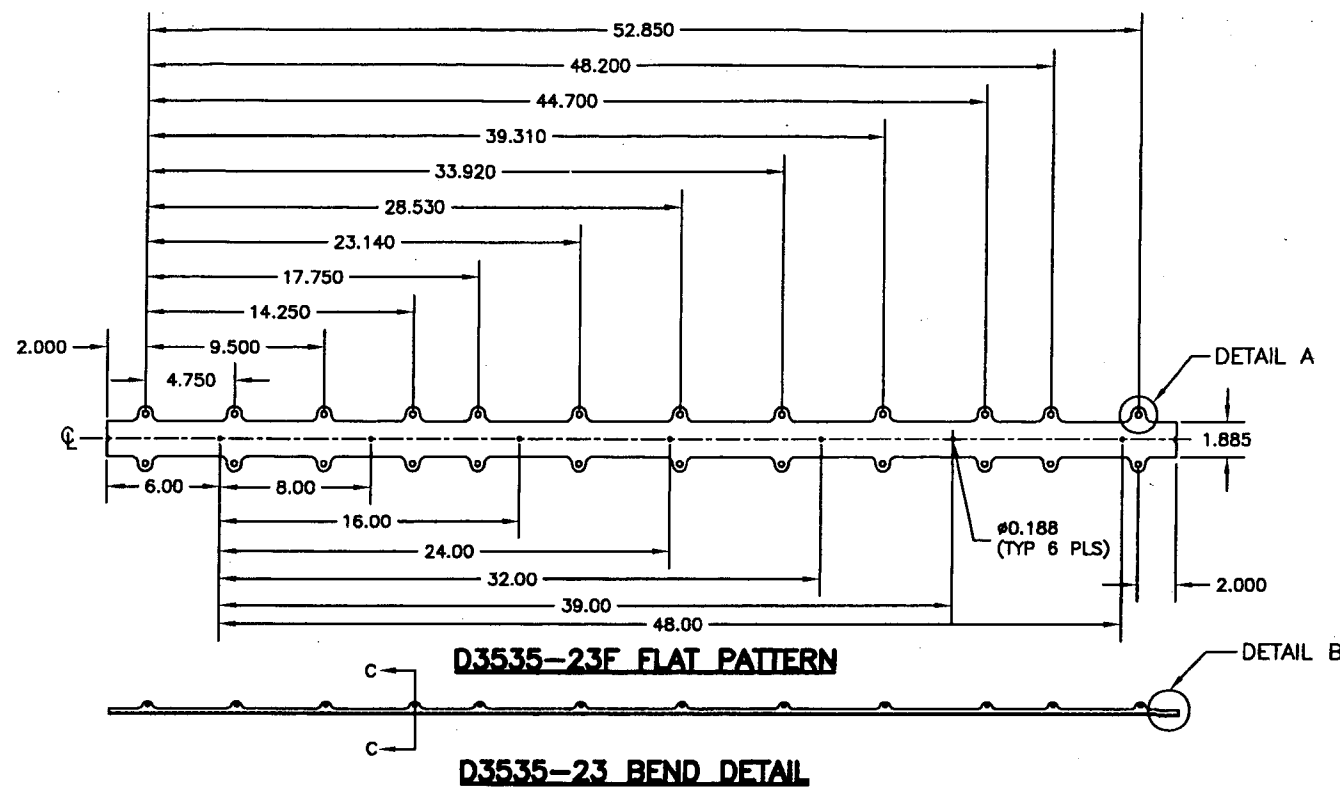
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05256

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				SCALE
				SHEET 3 OF 7
				REV. B

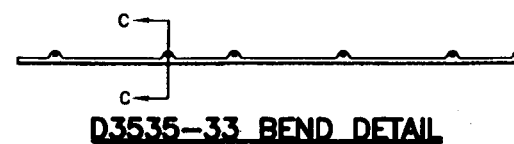
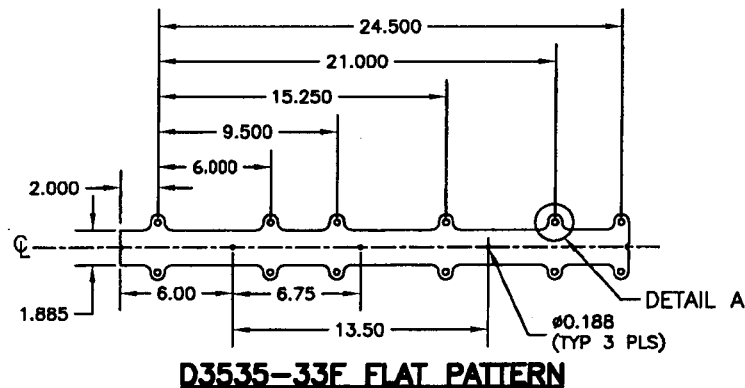
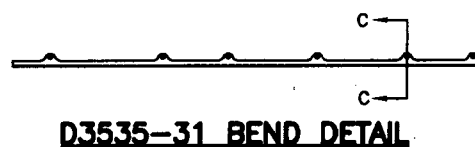
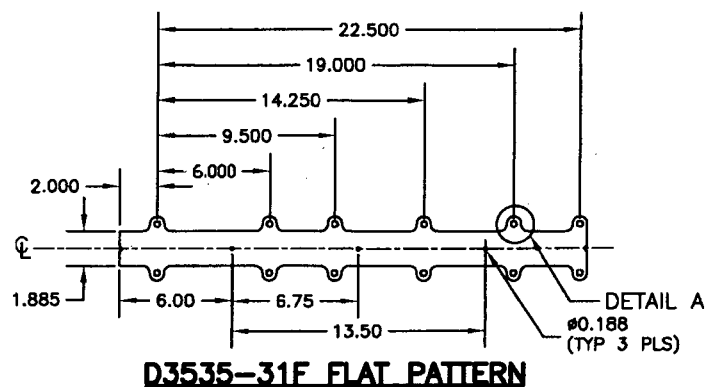


- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
 - 3) PART IS SYMMETRICAL ABOUT C
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES TO 0.010 MAX
 - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
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07.04.24**NOTES**

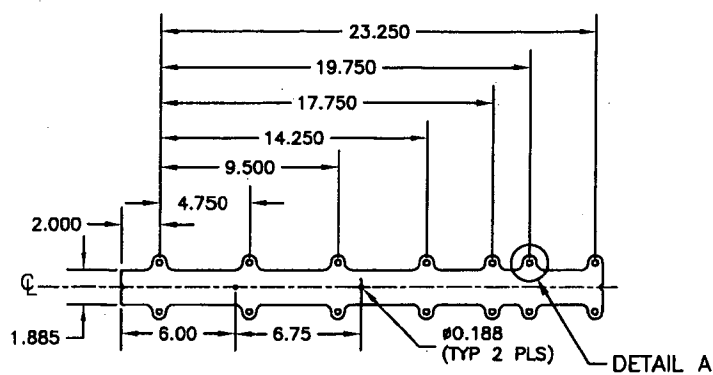
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(REF DART SPEC M304S20GA)
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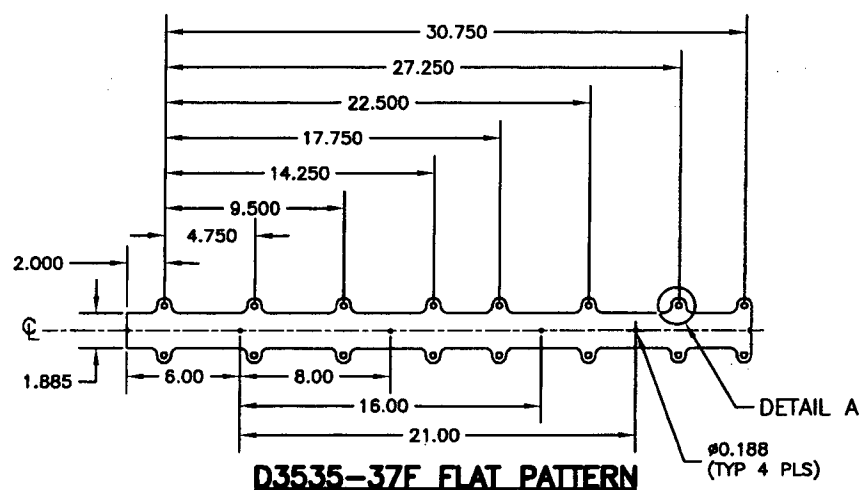
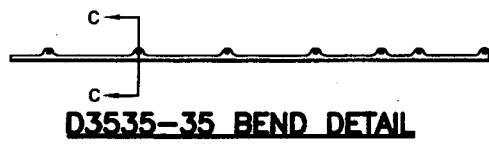
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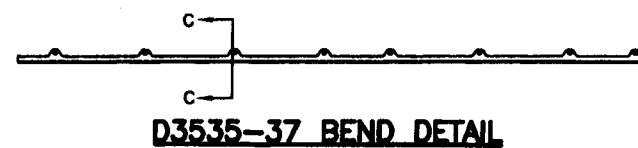
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		TITLE	WEARSHOE	SHEET 5 OF 7
		SCALE	1:10	



D3535-35F FLAT PATTERN



D3535-37F FLAT PATTERN



- NOTES**
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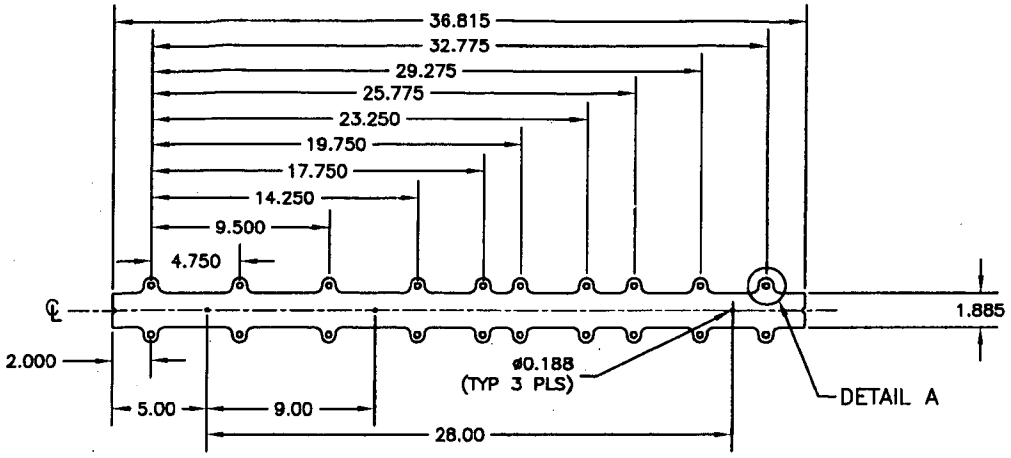
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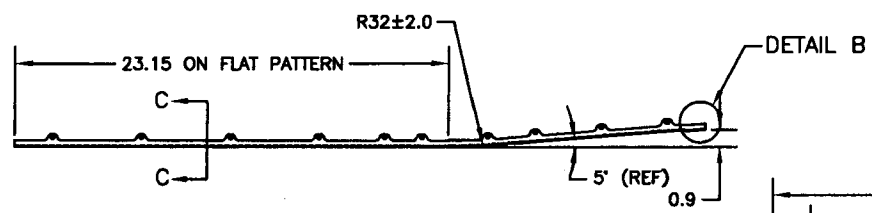
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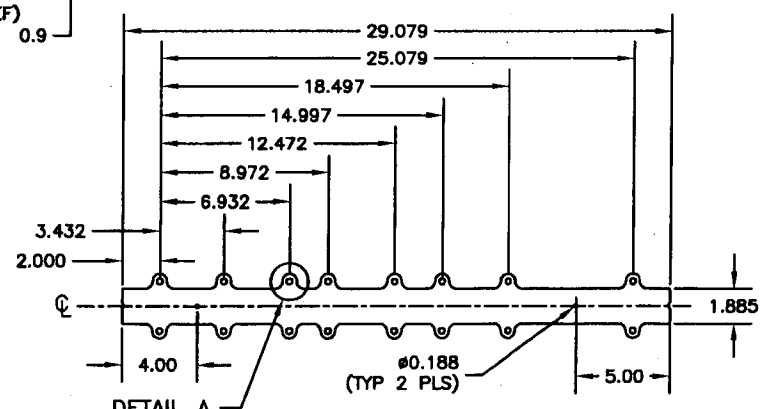
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 6 OF 7
		SCALE	1:10	



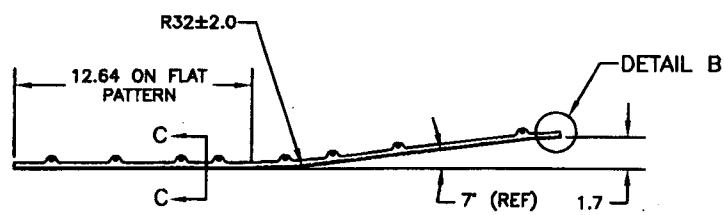
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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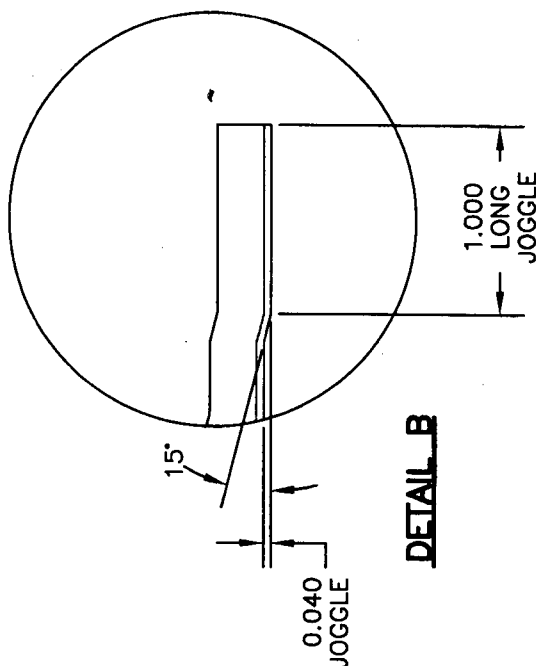
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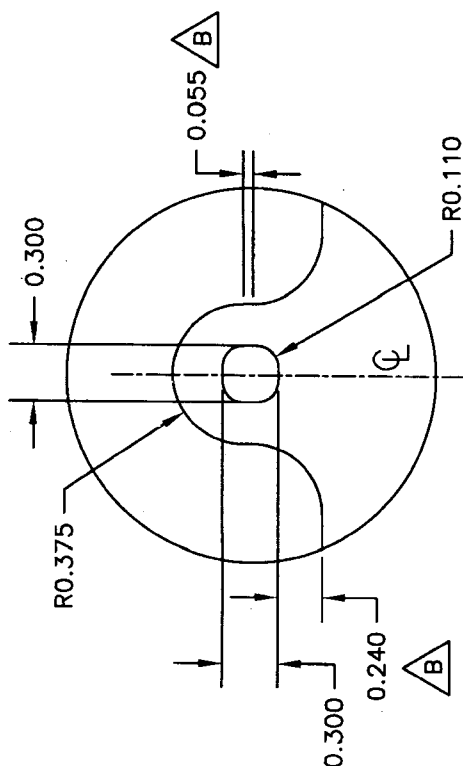
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DATE 07.04.17	TITLE WEARSHOE SCALE 1:1		

RELEASED

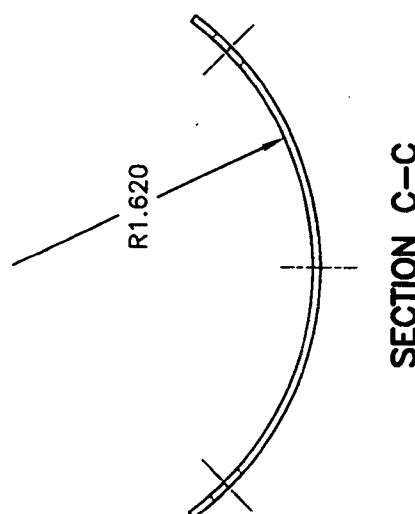
07.04.24



DETAIL B



DETAIL A



SECTION C-C

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